

April-24-14 11:12:50 AM

Page 1

Quality Control

Work Order ID 117439

April-24-14 11:12:50 AM

117439

Page 2

Item ID: D3240-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Frame

Start Date: 4/24/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/24/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

NA

DAS
30
9-89

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

6 7/16 14-8-25

150

150

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

6 14/08/25

Work Order ID 117439

117439

Page 3

April-24-14 11:12:50 AM

Item ID: D3240-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Frame

Start Date: 4/24/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/24/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location:

0.00

160

Packaging

Memo

0.00

Packaging

6X

DAS
28
9-89

AUG 25 2014

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 14-08-25

MLJ 14-08-25

Picklist Print

April-24-14 11:12:50 AM

Work Order ID: 117439

117439

Parent Item: D3240-1

D3240-1

Parent Item Name: Frame

Start Date: 4/24/14

Required Date: 4/24/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B05.04.28Added Step 6 & 7KJ/JLM
IPP Rev C now water jet 07-11-01 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	301.4339	2.534	4x 17		DAS 23 9-89	14-8-21
										**			
M2024T3S 063													
2024-T3 .063 sheet													

Location

Loc Qty

Loc Code

MAT022

301.4339

123701

16.1039

m127866

94.33

m128354

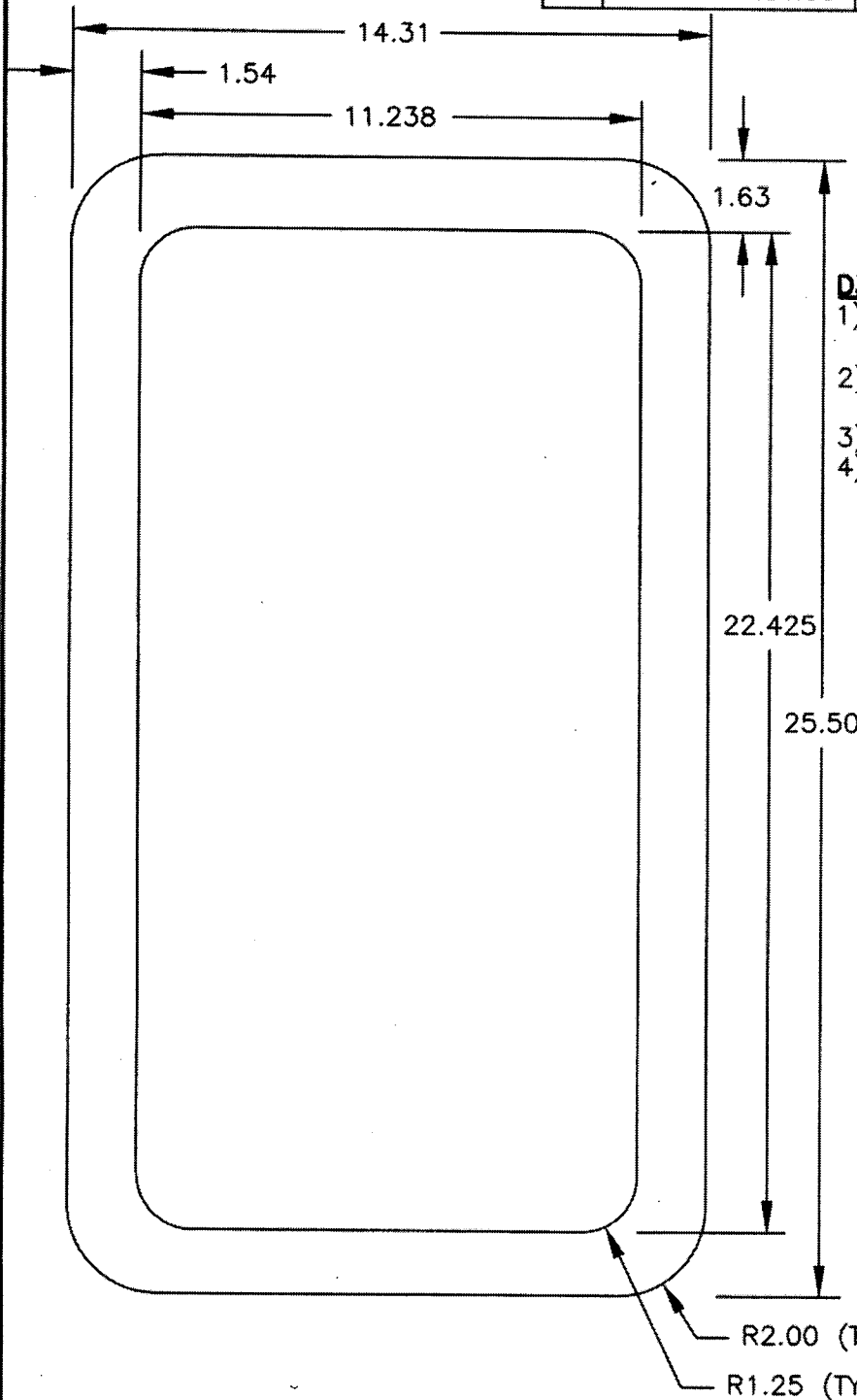
191

130 000

130 000

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3240	REV. B SHEET 1 OF 1
DATE 05.01.06		TITLE FRAME	SCALE NTS
A	03.12.18	NEW ISSUE	
B	05.01.06	25.50 WAS 25.19; 14.31 WAS 14.19	

**RELEASED**
05-02-02 [Signature]**D3240-1 FRAME**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

112439 NLS
1404-24

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.